

Work Order ID 58853

Wednesday, May 19, 2010 1:41:57 PM



Page 1

Item ID: D3933-2

Accept



Setup Start



Revision ID:

Item Name: Aft Cabin Wall Protector, RH

Stop



Start Date: 5/19/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 5-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3933

Dwg Rev: A

Prog Rev: A

2- Deburr if necessary

⇒ m-l 10/05/21 (4X)

B10-5-20

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B10-5-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 5/19/2010 Start Qty: 4.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 258A

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

(4)

Supp/26 (4)

10/05/26 (4)

R/10-5-26 (4)

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Picklist Print

Wednesday, May 19, 2010 1:42:00 PM

Page 1

Work Order ID: 58853



Parent Item: D3933-2



Parent Item Name: Aft Cabin Wall Protector, RH

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	2,018.975	7.01			
GE PLASTICS LEXAN SHEET												



1810-5-20

Location

Loc Qty

Loc Code

MAT

2018.9758

111710

64

112585

152.333

114032

1802.6428

114032

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 58853
Description: Aft Cabin Wall Protector, RH		Part Number: D3933-2
Inspection Dwg: D3933	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	.888	X			
19.00	+/-0.030	19.00	✓			
26.75	+/-0.030	26.75	✓			
27.38	+/-0.030	27.38	X			
34.75	+/-0.030	34.75	X			
31.50	+/-0.030	31.50	✓			
25.79	+/-0.030	25.79	✓			
0.125	+/-0.010	.134	X			
23.25	+/-0.030	23.25	✓			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 10-5-20	Date: 10/5/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.22	New Issue	KJ	AK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 58853

BS10-5-19

0.125
REF

R1.63

23.25

R0.50
TYP

0.75

0

0.88

19.00

26.75

27.38

25.79

0

31.50

34.75

D3933-1 AFT CABIN WALL PROTECTOR, LH
(TEXTURED SIDE SHOWN)

RELEASED
09/04/21

NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3933-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
- 7) WEIGHT: 4.94 lbs
- 8) CHECK PER TEMPLATE DT8921

A		NEW ISSUE		09.04.21	
REV.		DESCRIPTION	BY	DATE	
DESIGN	BE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	BE				
CHECKED	PH	DRAWING NO.		REV. A	
MFG. APPR.	BE	D3933		SHEET 1 OF 2	
APPROVED	AD	TITLE		SCALE	
DE APPR.	H	AFT WALL PROTECTOR		NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

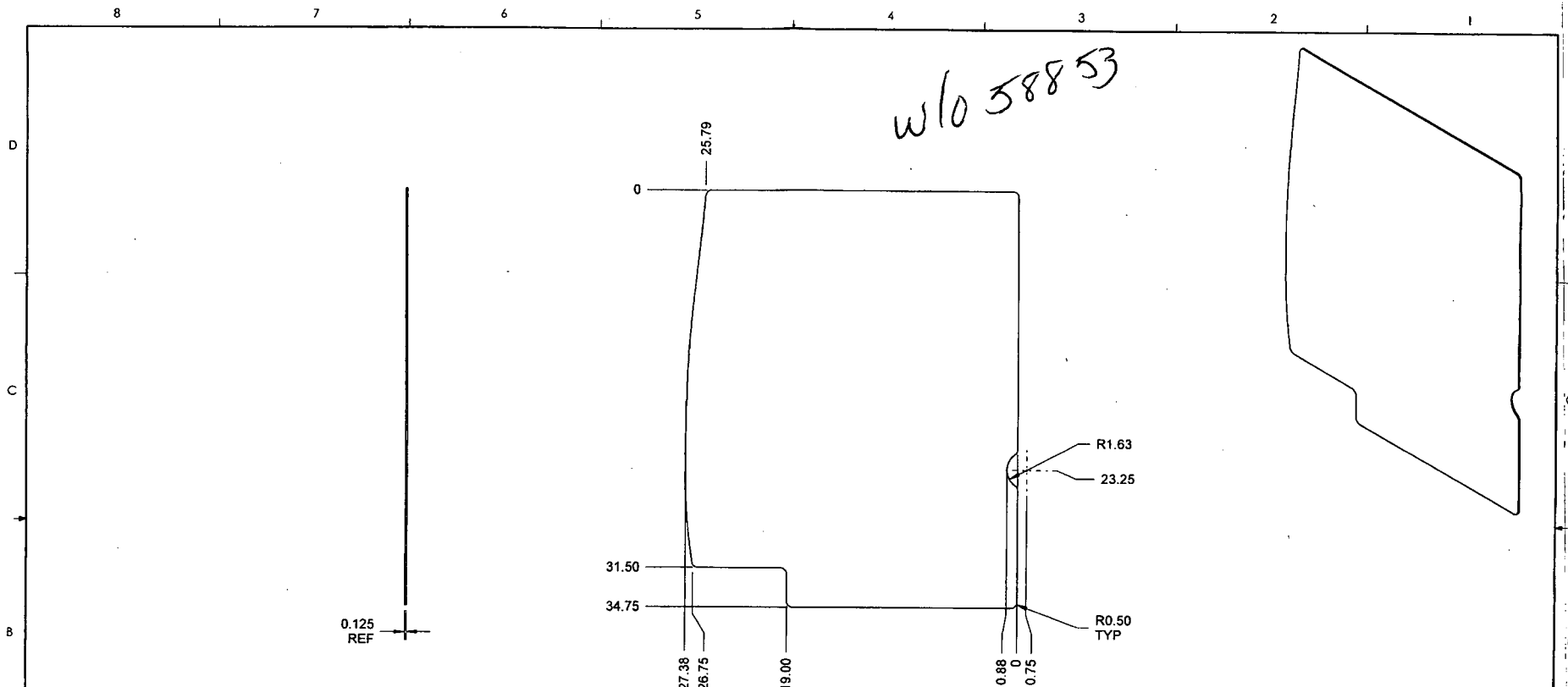
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

w/o 38853



D3933-2 AFT CABIN WALL PROTECTOR, RH
(TEXTURED SIDE SHOWN)

RELEASED
09/18/23 NH

NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3933-2" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
- 7) WEIGHT: 4.94 lbs
- 8) CHECK PER TEMPLATE DT8921

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3933	SHEET 2 OF 2
APPROVED		TITLE	
DE APPR.		AFT WALL PROTECTOR	
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NOTE: INFORMATION

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